



**NAVY CLOTHING AND TEXTILE RESEARCH FACILITY
NATICK, MASSACHUSETTS**

NAVAL UNIFORM CERTIFICATION PROGRAM BULLETIN

Bulletin No. 302

November 2015

---- In this Issue ----

NEW ITEM TO BE CERTIFIED

The Navy has approved a laser-cut USA Reverse Flag and Don't Tread on Me Flag to replace embroidered USA Reverse Flag and embroidered Don't Tread on Me Flag. The Non- IR and IR badges will be in the following styles:

STYLE A - Desert, USA Reverse Flag, Non-IR

STYLE B - Desert, Don't Tread On Me Flag, Non-IR

Components:

- a. Cloths, Ripstop, Nylon and Cotton Blend, Camouflage, NCTRF PD 05-11, Type II
- b. Cloth, Duck, Textured Nylon, MIL-DTL-32439, Type III, Class 1, Style A
- c. Fastener Tapes, Hook and Loop, Synthetic, A-A-55126. Hook tape shall be in accordance with Type II, Class 1 or 4, 2" wide.
- d. Thread, Polyester Core, Cotton or Polyester-Covered, A-A-50199, Type I or Type II, TEX Size range 36 to 45.

STYLE C - Woodland, USA Reverse Flag, Non-IR

STYLE D - Woodland, Don't Tread On Me Flag, Non-IR

Components:

- a. Cloths, Ripstop, Nylon and Cotton Blend, Camouflage, NCTRF PD 05-11, Type III, Class 2
- b. Cloth, Duck, Textured Nylon, MIL-DTL-32439, Type III, Class 1, Style A
- c. Fastener Tapes, Hook and Loop, Synthetic, A-A-55126. Hook tape shall be in accordance with Type II, Class 1 or 4, 2" wide.
- d. Thread, Polyester Core, Cotton or Polyester-Covered, A-A-50199, Type I or Type II, TEX Size range 36 to 45.

STYLE E - Desert, USA Reverse Flag, IR

STYLE F - Desert, Don't Tread On Me Flag, IR

Components:

- a. Cloths, Ripstop, Nylon and Cotton Blend, Camouflage, NCTRF PD 05-11, Type II
- b. Fastener Tapes, Hook and Loop, Synthetic, A-A-55126. Hook tape shall be in accordance with Type II, Class 1 or 4, 2" wide.
- c. Thread, Polyester Core, Cotton or Polyester-Covered, A-A-50199, Type I or Type II, TEX Size range 36 to 45.
- d. Infrared Reflectance Tape: must contain a certified style listed in section 3

STYLE G - Woodland, USA Reverse Flag, IR

STYLE H - Woodland, Don't Tread On Me Flag, IR

Components:

- a. Cloths, Ripstop, Nylon and Cotton Blend, Camouflage, NCTRF PD 05-11, Type III, Class 2
- b. Fastener Tapes, Hook and Loop, Synthetic, A-A-55126. Hook tape shall be in accordance with Type II, Class 1 or 4, 2" wide.
- c. Thread, Polyester Core, Cotton or Polyester-Covered, A-A-50199, Type I or Type II, TEX Size range 36 to 45.
- d. Infrared Reflectance Tape: must contain a certified style listed in section 3

1. Colors.

- a. Woodland badges: Duck cloth or IR tape shall be black. Hook fastener tape and thread shall be a close match to FED-STD-595/34094 Green, Pigment
- b. Desert badges: Duck cloth or IR tape shall be black. Hook fastener tape and thread shall be a close match to FED-STD-595/20180 Brown, Semi gloss

2. Laser Cut Designs. The laser cut designs shall be in accordance with:

- a. Don't Tread on Me: DTOM_laser.dst
- b. USA Reverse Flag: USAflag_laser.dst

3. Infrared Reflectance Tape.

IR tape must be a certified style acquired from one of the following approved vendors:

- a. Cejay Engineering, LLC
- b. Cyalume Technologies, Inc.

4. Construction.

- a. Non-IR (Styles A-D)
 - i. Cut duck cloth and hook fastener tape to finished dimensions. Laser-cut the badge design on the face of the ripstop cloth leaving a 1/2" seam allowance.
 - ii. With both duck cloth and laser-cut design face up, fuse duck cloth to center back of laser-cut design. Duck cloth shall cover all open spaces of laser-cut design.
 - iii. Turn in ripstop seam allowance to encompass all layers and press.
 - iv. Position hook fastener tape over the folded seam allowance with hook side out and topstitch through all layers 1/8" from folded edge.
- b. IR (Styles E-H)

Follow the same steps as Non-IR but replace duck cloth with IR tape.
- c. Note: If a polyester reinforcement is required to maintain flag shape, a .007mil is acceptable.

5. Finished Flag Dimensions.

Height: 2-1/8" ± 1/16"

Length: 3-3/4" ± 1/16"

7. Figures:



Style A



Style B



Style C



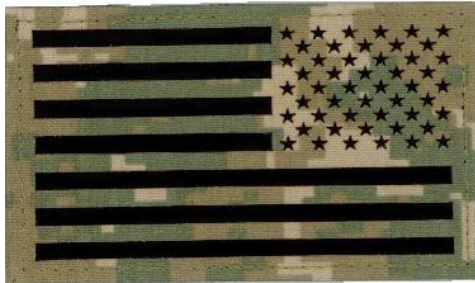
Style D



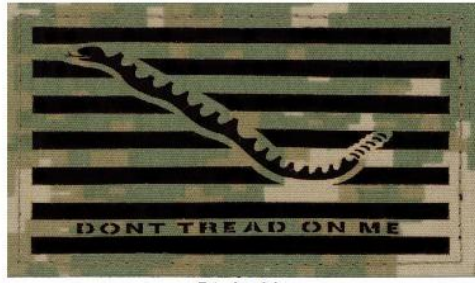
Style E



Style F



Style G



Style H